

Date: Thursday, 7/3/2008 3:32:26 PM  
 User: Kim Johnston

3

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	DART 13-MAN 3-POINT SHOULDER HARNESS KIT		
Job Number	40226			Part Number	D412702041B		
Estimate Number	12865			Drawing Number	IIN D412-702 REV E		
P.O. Number	:			Project Number	N/A		
This Issue	7/3/2008	S.O. No.	:	Drawing Revision	E		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	SMALL /MED FAB	Due Date	7/30/2008	Qty:	1
Previous Run	32760			Um:	Each		
Written By	<u>JLD 08.07.08</u>						
Checked & Approved By							
Comment	est rev A 07.05.10 new issue EC est rev C 07.06.20 changed AN44 4A to AN444A EC Est Rev:D 07-07-06 As per Rev E JLM Est Rev:E 08-03-31 now at chg003 ECN1150 DD verified by:						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	 <i>JLD 08.7.08</i>
		Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D412-702-041B CHG003	 <i>S08.07.08</i>
2.0	D412702059	Grommet	 <i>All *</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) GROMMET KIT batch: <i>40187</i>	 <i>SQ</i>
3.0	D412702101B	Harness Assembly	 <i>S</i>
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) HARNESS ASSEMBLY batch: <i>32484</i>	 <i>SQ</i>
4.0	D412702103B	Harness Assembly	 <i>S</i>
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) HARNESS ASSEMBLY batch: <i>32485</i>	 <i>SQ</i>
5.0	D412702105B	Harness Assembly	 <i>X</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) HARNESS ASSEMBLY batch: <i>32486</i>	 <i>SQ</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/3/2008 3:32:26 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 40226

Part Number: D412702041B

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D412702107B Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Harness Assembly

batch: 32487

SP

7.0 D412702109B Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Harness Assembly

batch: 32488

SP

8.0 D412702111B Harness Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Harness Assembly

batch: 32609

SP

9.0 D412702113B Harness Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Harness Assembly

batch: 32610

SP

10.0 D412702115B Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Harness Assembly

batch: 32491

SP

11.0 D412702117B Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Harness Assembly

batch: 32492

SP

12.0 D35421 Bracket



X

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

batch: 38294

8/7/10

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/3/2008 3:32:27 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 40226

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0 D35711

Guide

8/7/10 S



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

GUIDE

batch: 31868

(6)

~~New Batch#~~

SP

14.0 D35713

Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GUIDE

batch: 31869

SP

15.0 D3572041

Guide Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GUIDE ASSEMBLY

batch: 31870

SP

16.0 D3578041

Doubler



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

DOUBLER

batch: 32483

SP

17.0 D3610041

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BRACKET

batch: 32607

SP

18.0 D36181

CAP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CAP

batch: B 32426

SP

19.0 AN410A

Bolt



(X)

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: 101291

8/7/10

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/3/2008 3:32:27 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 40226

Part Number: D412702041B

Job Number:



Seq. #:	Machine Or Operation:	Description :	
20.0	AN416A	Bolt	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt batch: 18499		SP
21.0	AN425A	BOLT	
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) BOLT batch: 104438		SD
22.0	AN444A	Bolt	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) bolt batch: 104806		SP
23.0	MS24693S274	Screw	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Screw batch: 104214		SP
24.0	MS24694S56	SCREW	
	Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) SCREW batch: 14198		SP
25.0	MS24694S58	Screw	
	Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s) Screw batch: 11735		SP
26.0	MS24694S60	Screw	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Screw batch: 11706	8/1/10	SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/3/2008 3:32:27 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 40226

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Washer

batch: 107939

SP

28.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: 103942

SCD

29.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: 107478

SP

30.0

CR321244

Cherry Rivet



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Cherry Rivet

batch: 16894

8/7/10

SD

31.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/07/10 CSD

32.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-041B CHG003

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_ Rev C

8/08/10 CSD

33.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/10 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
X					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit
	X				D412-702-043B	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X		D412-702-047B	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X	D412-702-049B	Dart 1-Man 3-Point Forward Shoulder Harness Kit
1	1		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101B	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
2	1		1		D412-702-103B	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-045	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1	1			1	D412-702-105B	HARNESS ASSEMBLY
1*	1*			1*	D3573-1	ADAPTER
1*	1*			1*	D3579-046	SHOULDER HARNESS
1*	1*			1*	K6.2	CLIP
4*	4*			4*	MS24693S273	SCREW
4*	4*			4*	AN960JD10LL	WASHER
4*	4*			4*	MS21042L3	NUT
1	1				D412-702-107B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-046	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1	1				D412-702-109B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-045	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER  
NO. 40234

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
2		2			D412-702-111B	HARNESS ASSEMBLY
1*		1*			D3570-1	BRACKET
1*		1*			D3579-047	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
2		2			D412-702-113B	HARNESS ASSEMBLY
1*		1*			D3570-2	BRACKET
1*		1*			D3579-048	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1				1	D412-702-115B	HARNESS ASSEMBLY
1*				1*	D3573-5	ADAPTER
1*				1*	D3579-046	SHOULDER HARNESS
1*				1*	K6.2	CLIP
4*				4*	MS24693S272	SCREW
4*				4*	AN960JD10LL	WASHER
4*				4*	MS21042L3	NUT
1				1	D412-702-117B	HARNESS ASSEMBLY
1*				1*	D3573-5	ADAPTER
1*				1*	D3579-045	SHOULDER HARNESS
1*				1*	K6.2	CLIP
4*				4*	MS24693S272	SCREW
4*				4*	AN960JD10LL	WASHER
4*				4*	MS21042L3	NUT
2	2				D3542-1	BRACKET
7	3		4	1	D3571-1	GUIDE
2	2				D3571-3	GUIDE
2		2			D3572-041	GUIDE ASSEMBLY
12	6		6	2	D3578-041	DOUBLER
2	2				D3610-041	BRACKET
2	2				D3618-1	CAP
4	4				AN4-10A	BOLT
2		2			AN4-16A	BOLT
4		4			AN4-25A	BOLT
2	2				AN4-44A	BOLT
2	2				MS24693S274	SCREW
3	3			1	MS24694S56	SCREW
10	2		8		MS24694S58	SCREW
1	1			1	MS24694S60	SCREW
26	6	20			AN960JD416	WASHER
4	4				AN960JD416L	WASHER
12	6	6			MS21042L4	NUT
24	12		12	4	CR3212-4-4	RIVET

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 40226